

Date: Friday, 07/03/2008 10:41:04 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 FLOAT SKIDTUBE
 Job Number : 37688
 Estimate Number : 11437
 P.O. Number :
 This Issue : 07/03/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : LANDING GEAR
 Previous Run : 37687
 Written By : J.M. 08.03.07
 Checked & Approved By :
 Comment :
 est rev A 05.12.13 New issue EC
 est rev B 06.02.09 Dwg @ revD EC
 est rev C 07.03.13 dwg @ revF ec
 est rev D 07.10.31 ecn 1053P EC
 Est Rev:E ECN 1056 07-11-13 DD verified by: EC

Part Number : D3391015
 Drawing Number : D3391 REV G
 Project Number : N/A
 Drawing Revision : G
 Material :
 Due Date : 14/03/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0

D6014090

ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014090 Extrusion 832309

Identify as D3391-3

J.F. 08/03/09 (1)

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

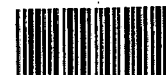
Rev: 44 & Dwg D3391 Rev: G

J.F. 08/03/09 (1)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/03/09 (1)

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

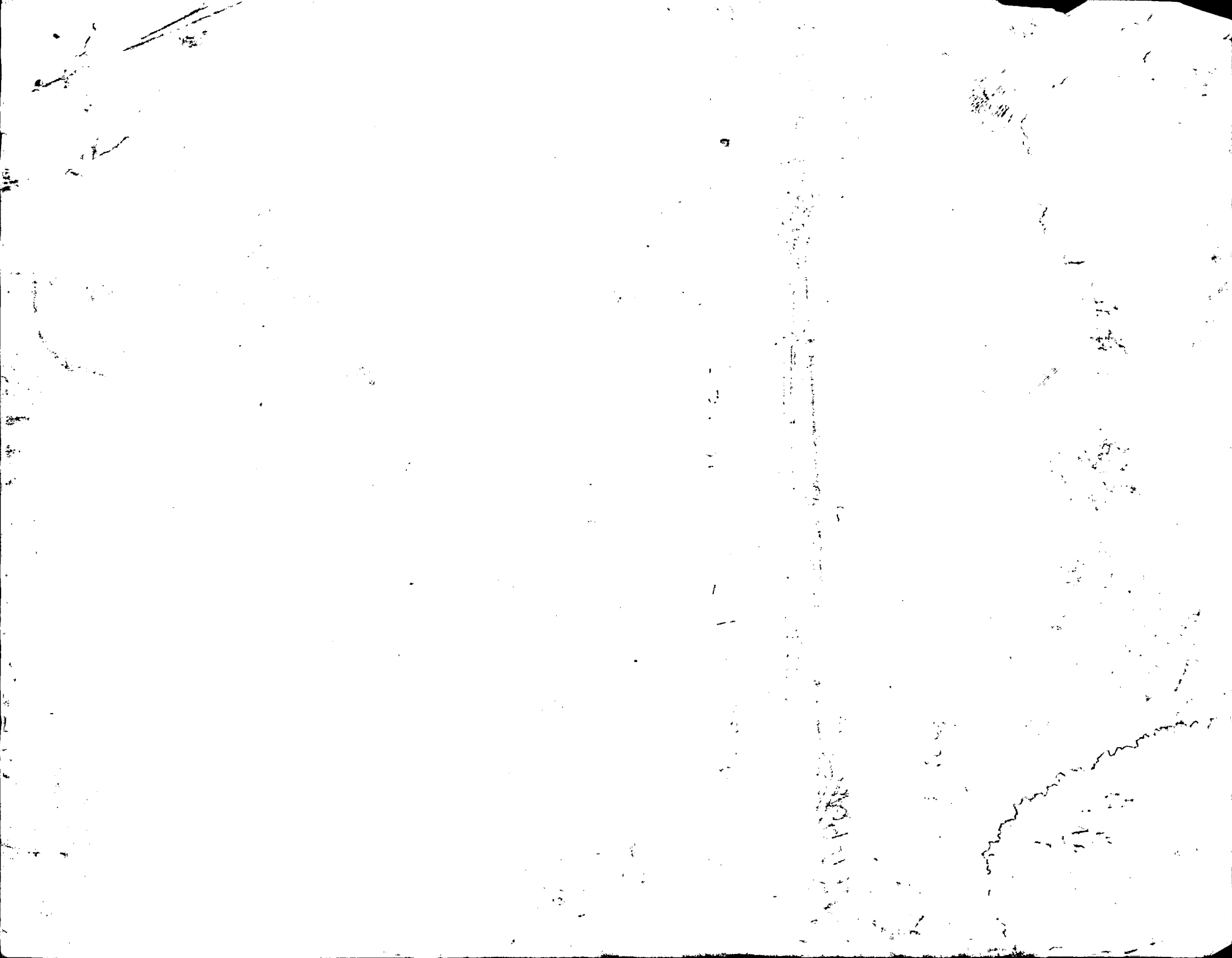


Comment: HAAS

1-Machine as per Folio FA 599 Rev: 44 & Dwg D3391 Rev: G

2-Debur

J.L. 08/07/31



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/07/31

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 08/08/01

7.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: NC Bender

Form as per Dwg D3391

DP 8-8-5

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/08/05 (20)

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8808 (ALL HOLES)

3-Drill and c' sink wearshoe holes as per Dwg D3391

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391
Deburr

5- Tranfer holes from D3391-013 for electric step in tube

M
8-8-7

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/09/07 (A)



Date: Friday, 07/03/2008 10:41:04 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

DP 8-8-18

13.0 ~~D36704200~~ SPACER



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)
SPACER
Batch: ~~B36318~~ 8-8-18

(14)

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
1-Install crossbolt spacers per dwg D3391

A/R Magnabond 6398 batch: M107621 Exp. 9-8-1

M 8-8-18

2- Grind flush

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/00 (40)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M108523

M 08/08/25

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-26 (KV)

18.0 ~~D2646~~ Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

Batch: ~~B337377~~

M 08-08-26 (KV)

Date: Friday, 07/03/2008 10:41:05 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B38947

20.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

Batch: B33869

21.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B32740

22.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B33870

23.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

Batch: B39275

24.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

Batch: A4105819

or equivalent per

QSI 017

25.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

Batch: A4100484

08-08-06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent
per QSI 017

26.0

~~ALS4428165~~

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inserts

Batch: ~~M16489~~ *96*

27.0

~~AN3C4A~~

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: ~~A108599~~ *96*

28.0

~~AN3C5A~~

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: ~~A108747~~ *96*

29.0

~~AN960C10L~~

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: ~~A108618~~ *96*

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: *✓* SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts per dwg D3391

2-Install Aft Cap as per Dwg D3391

✓ A/R Sikaflex-241/291 *M108801*

Sikaflex expiry date: *08/10*

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

970

Date: Friday, 07/03/2008 10:41:05 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

33.0

QC21

FINAL INSPECTION/W/O RELEASE



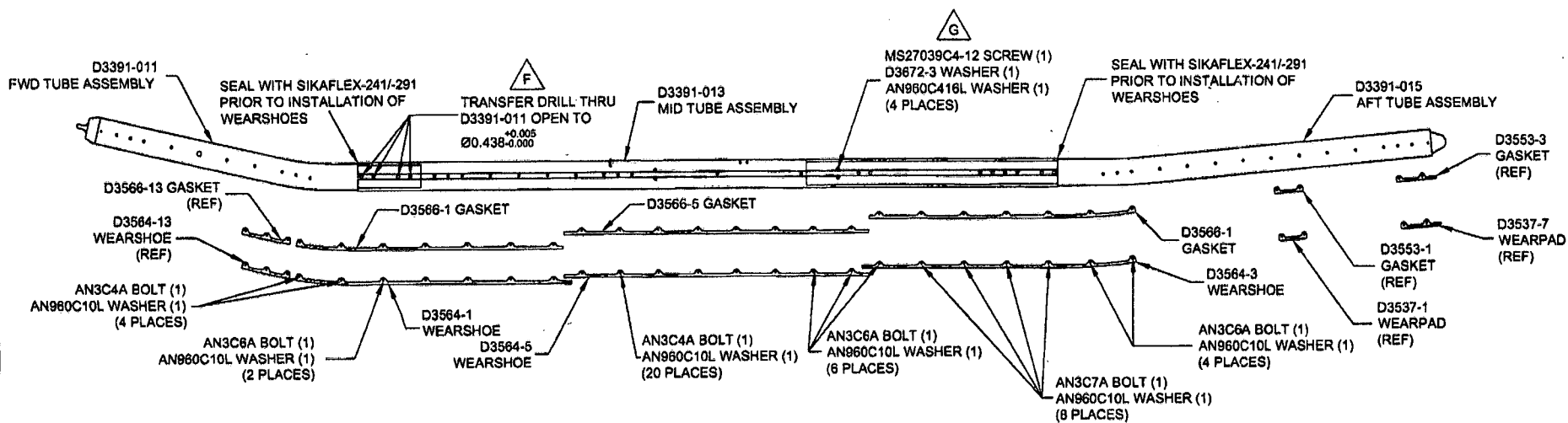
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-07

w/o 37688.



D3391-041 ASSEMBLY

RELEASED
07.11.06

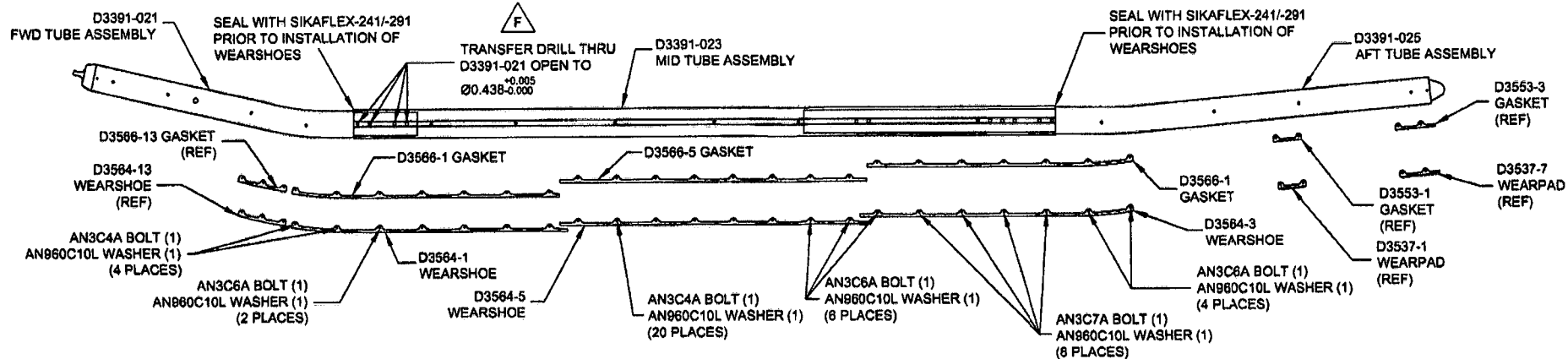
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JFC	PORT HADLOCK, WA	
CHECKED	JFC	DRAWING NO.	REV. G
MFG. APPR.	JFC	D3391	SHEET 1 OF 8
APPROVED	JFC	TITLE	SCALE
DE APPR.	JFC	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 ASSEMBLY

RELEASED
07.11.94

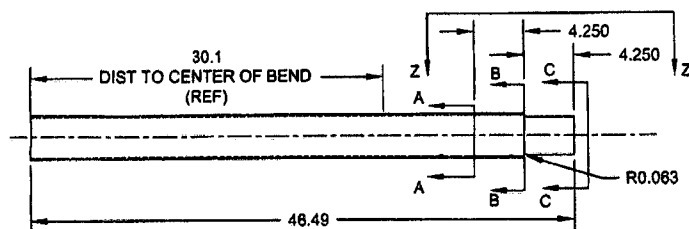
D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN860C10L	WASHER

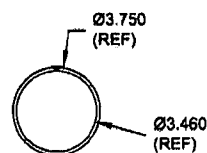
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

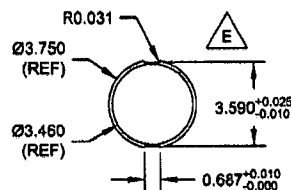
DESIGN	AW	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. G
MFG. APPR.	SC	D3391	SHEET 2 OF 8
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



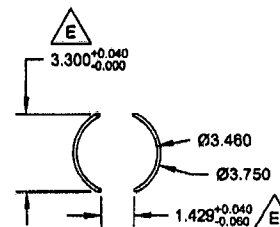
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



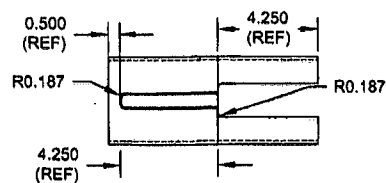
SECTION A-A
(SCALE 1:5)



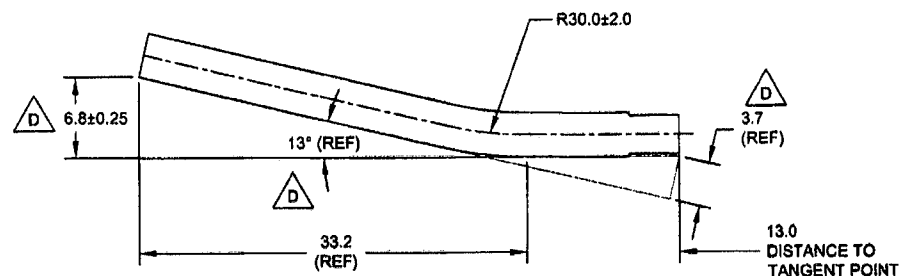
SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



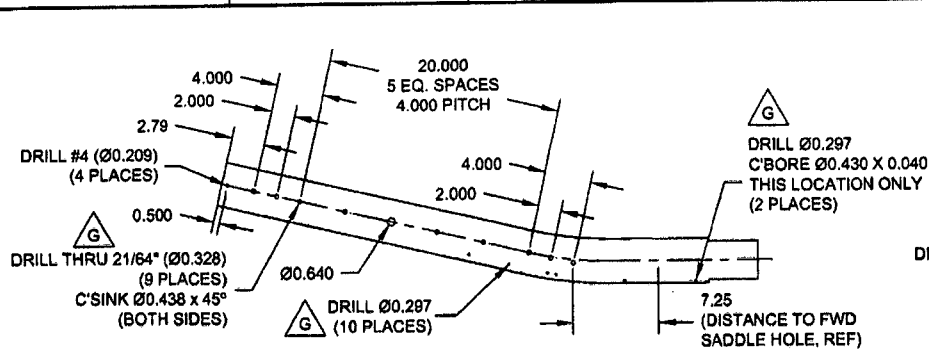
VIEW Z-Z
(SCALE 1:5)



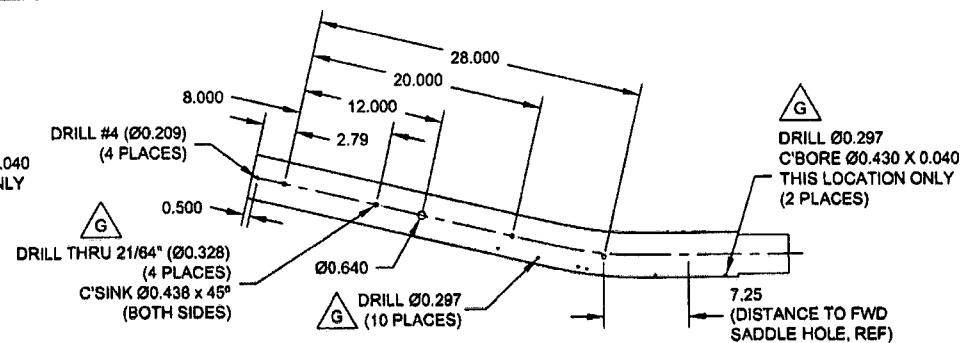
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

RELEASED
07-11-06 11P

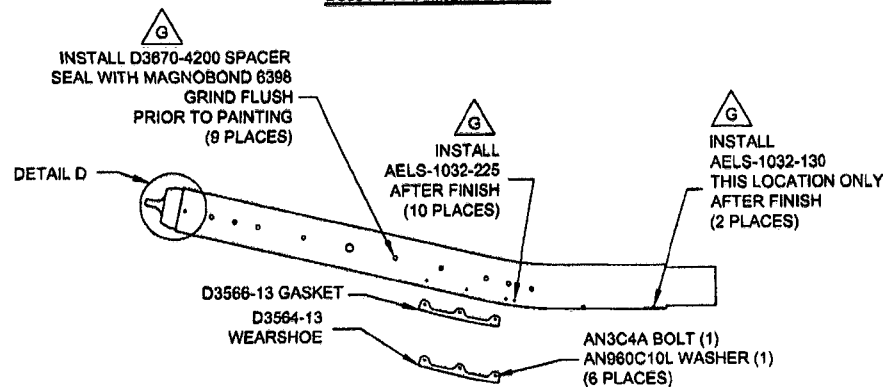
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
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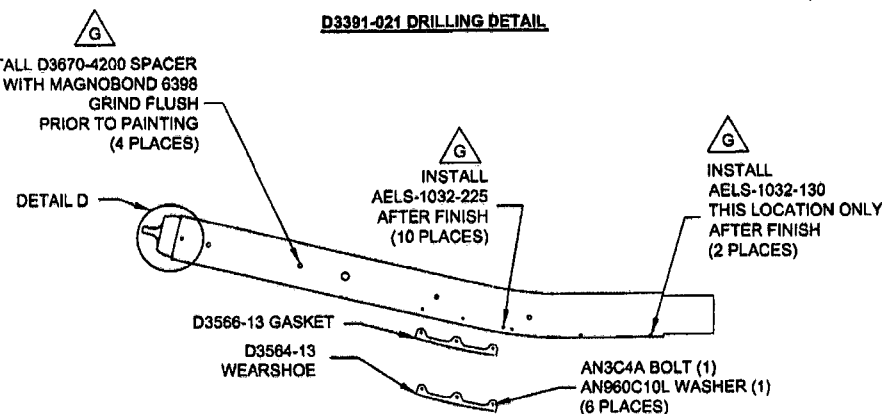
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL



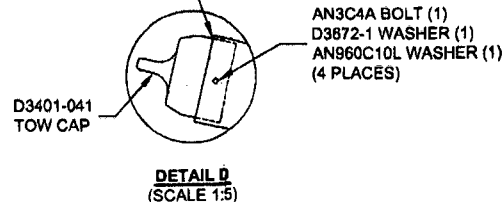
D3391-021 ASSEMBLY DETAIL

RELEASED
07.11.06

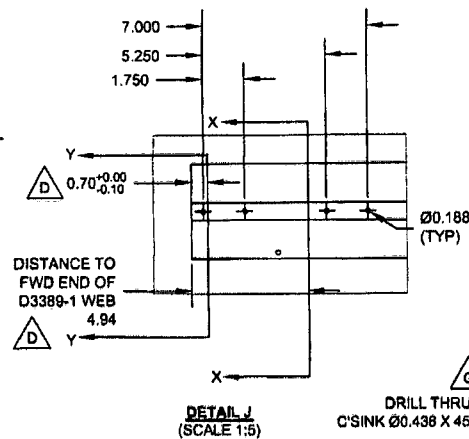
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D8013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

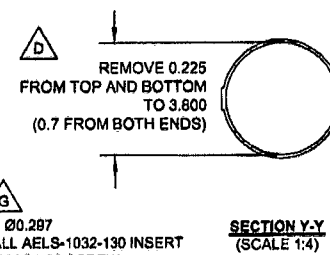
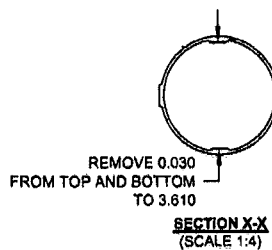
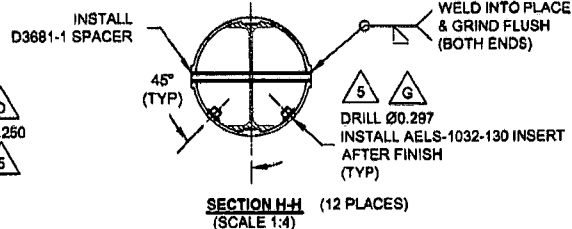
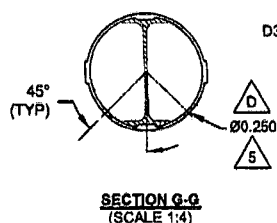
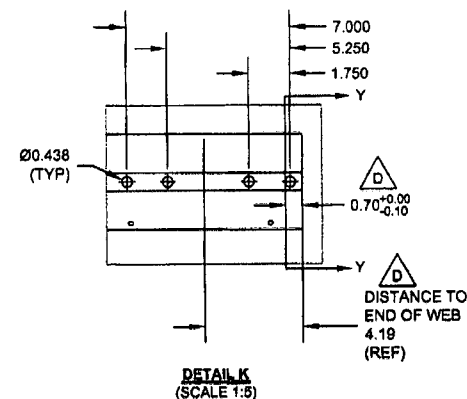
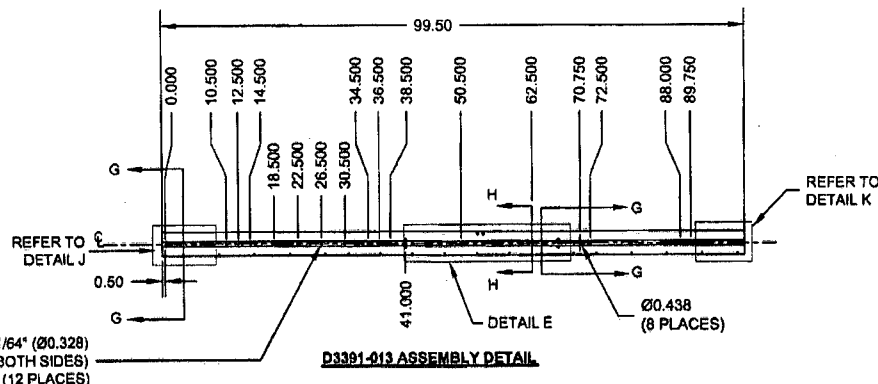
SEAL WITH
SIKAFLEX-241/-291



DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

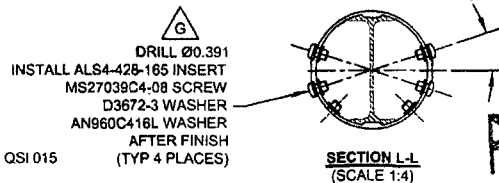
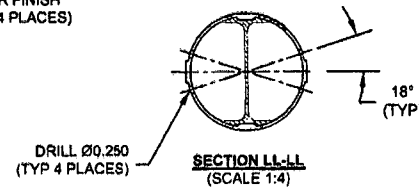
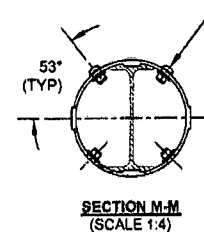
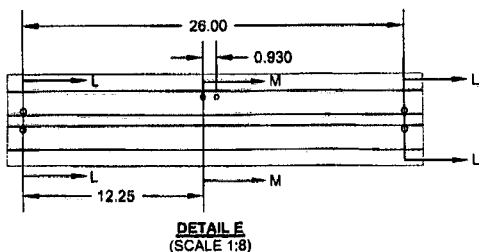


DRILL THRU 21/64" (Ø0.328)
C/SINK Ø0.438 X 45° (BOTH SIDES)
(12 PLACES)



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

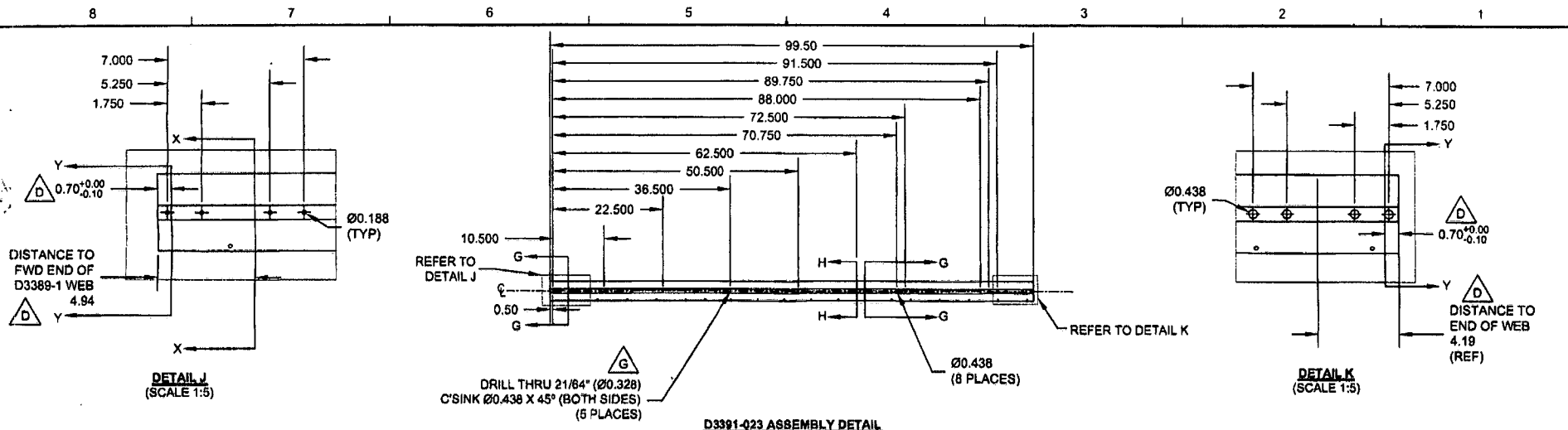


RELEASED

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	DP	DRAWING NO.	REV. G
MFG. APPR.	DP	D3391	SHEET 5 OF 8
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	



D3391-023 MID TUBE ASSEMBLY PARTS LIST

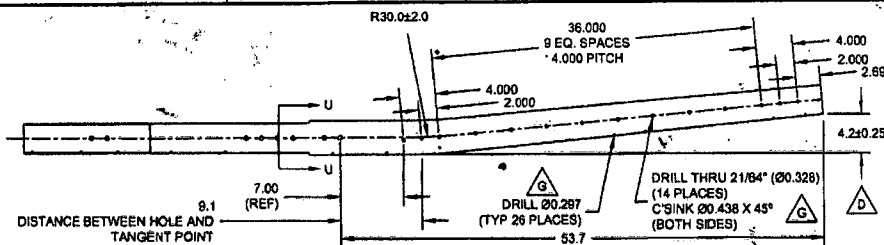
QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3381-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

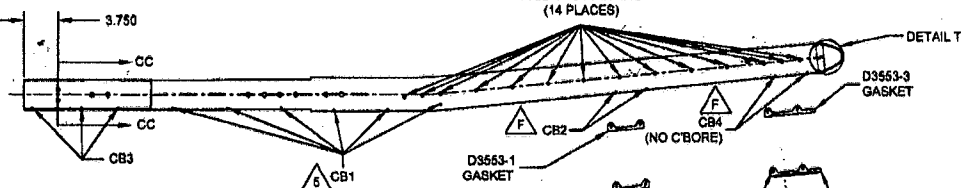
RELEASED
07.11.06/11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	DE	PORT HADLOCK, WA	
CHECKED	LS	DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	ST	412 FLOAT SKIDTUBE	1:20
DATE	07.07.31	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6396
GRIND FLUSH
PRIOR TO PAINTING
(14 PLACES)



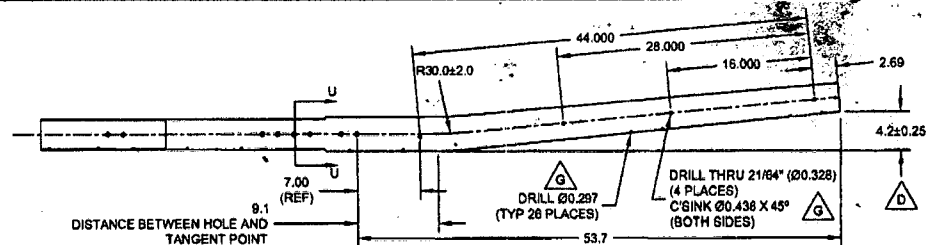
D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

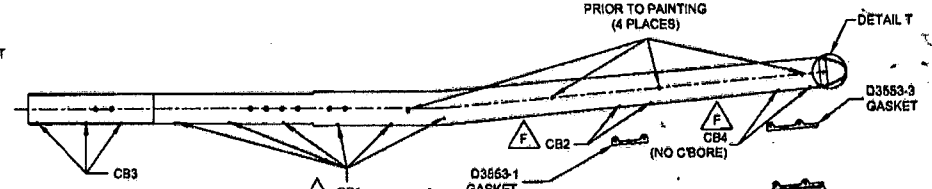
C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

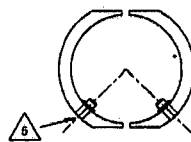


D3391-025 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

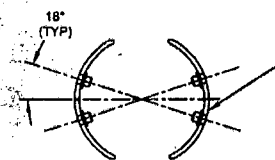
INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6396
GRIND FLUSH
PRIOR TO PAINTING
(4 PLACES)



D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

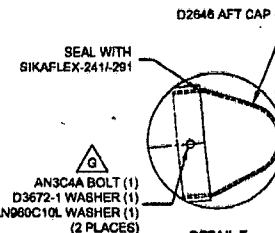


SECTION U-U
(SCALE 1:3)



SECTION CC-CC
(SCALE 1:3)

DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



DETAIL T
(SCALE 1:3)

RELEASED
07.11.06

DESIGN -	PH	DART AEROSPACE USA, INC
DRAWN	DC	PORT HADLOCK, WA
CHECKED	JS	DRAWING NO. D3391
MFG. APPR.	JS	REV. G
APPROVED	JS	SHEET 8 OF 8
DE APPR.	JS	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE 1:12

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DART AEROSPACE LTD		Work Order: 37688
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

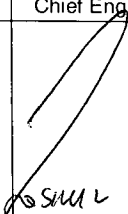



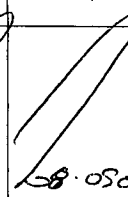
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000"	✓			
3.500	+/-0.010	3.504"	✓			
88.93	+/-0.030	88.930"	✓			
44.995	+/-0.030	45.00	✓			
3.200	+/-0.010	3.204	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	.201	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.296	✓			
0.200	+/-0.010	.202	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

Measured by: J.F./J.L.	Audited by: J.F.	Prototype Approval: N/A
Date: 08/03/09	Date: 08/08/01	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-05 PAR #: N/A Fault Category: Prod / Skid tube NCR: (Yes) No DQA: A Date: 09/04/09
 Resolution: D412-742 p41 Disposition: N/A QA: N/C Closed: D Date: 09/04/09

NCR: <u>37688</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.09.01	10.0	open ASS-y like holes CC-CC do not line up, with the mid-tube. tube is scrap. R.C. process.		Scrap & destroy no replace.	 9-4-7			

NOTE: Date & initial all entries